

Work Order ID 53599

November 9, 2009 1:42:05 PM



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Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Basket Lid Assembly					
Start Date:	09/11/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	20/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								

* Converted to upgrade for DS19473

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989
 - 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
 - 3- to locate hinges and shims use D2989-041, weld as per dwg D2989
- A/R ER316 S.S. Rod Batch: 1109213

PD 09.11.11
09/11/12

(1x)

110 0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control






09 11 13



Work Order ID 53599


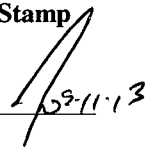
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Item ID: D2989-043 Accept  Setup Start 
Revision ID: D Stop 
Item Name: Basket Lid Assembly
Start Date: 09/11/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 20/11/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00				1			 09/11/09

130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat Powder Coating	* Pressure Wash Memo - Plug holes prior to powder coating	0.00							 09/11/09  

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989





11/12/09
1ST COAT
START TIME: 10:45 AM
OVEN TEMPERATURE: 400°F
FINISH TIME: 11:15 AM
***** 2nd coat if necessary *****
2ND COAT:
START TIME: 11:15 AM
OVEN TEMPERATURE: 400°F
FINISH TIME: 11:45 AM



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Item ID: D2989-043 Accept  Setup Start 
Revision ID: D Stop 
Item Name: Basket Lid Assembly
Start Date: 09/11/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 20/11/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	MO 09/11/12			X1			
150  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PPP 53596	0.00 0.00							09/11/2009
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							09/11/26 PA 09-11-25

Picklist Print

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Work Order ID: 53599



Parent Item: D2989-043RevD



Parent Item Name: Basket Lid Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	18.0000	1.0000			
Rib												

SAD 09-11-19

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
48101	1	
Main Warehouse		
WA	17	
51872	5	
53213	12	

PD 09.11.11

D2989-3RevD

Manufactured No

100

Each

3.0000

1.0000



Rib

SAD 09-11-19

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
51341	1	
53133	2	

PD 09.11.11

Picklist Print

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Work Order ID: 53599



Parent Item: D2989-043RevD



Parent Item Name: Basket Lid Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2989-4RevD		Manufactured	No			100	Each	3.0000	1.0000			
Rib												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
51342	1	
53132	2	

PD 09.11.11

D2989-5RevD		Manufactured	No			100	Each	4.0000	2.0000			
Rib												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	4	
51873	4	

PD 09.11.11

D3182-1RevA		Manufactured	No			100	Each	6.0000	2.0000			
Hinge												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
51253	6	

PD 09.11.12

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Shop Packet Print

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Picklist Print

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Work Order ID: 53599

Parent Item: D2989-043RevD

Parent Item Name: Basket Lid Assembly


Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-3RevA  Shim		Manufactured	No			100	Each	16.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
42718	1	
51302	1	
<u>53137</u>	14	

2x PD 09.11.12

D3827-041RevA  Rib Assembly (Inboard)		Manufactured	No			100	Each	6.0000	1.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
51339	1	
53247	5	

PD 09.11.11

D3832-5RevA  Mesh (Lid)		Manufactured	No			100	Each	4.0000	1.0000			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4	
50020	1	
52049	3	

PD 09.11.11

Picklist Print

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Work Order ID: 53599



Parent Item: D2989-043RevD



Parent Item Name: Basket Lid Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3833-5RevA		Manufactured	No			100	Each	10.0000	2.0000			

Mesh (Lid End)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

10

51305

10

D3838-041RevA

Manufactured

No

100

Each

3.0000

1.0000



Rib Assembly (Basket Lid, LH)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

51334

1

53134

2

D3838-042RevA

Manufactured

No

100

Each

3.0000

1.0000



Rib Assembly (Basket Lid, RH)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

51335

1

53135

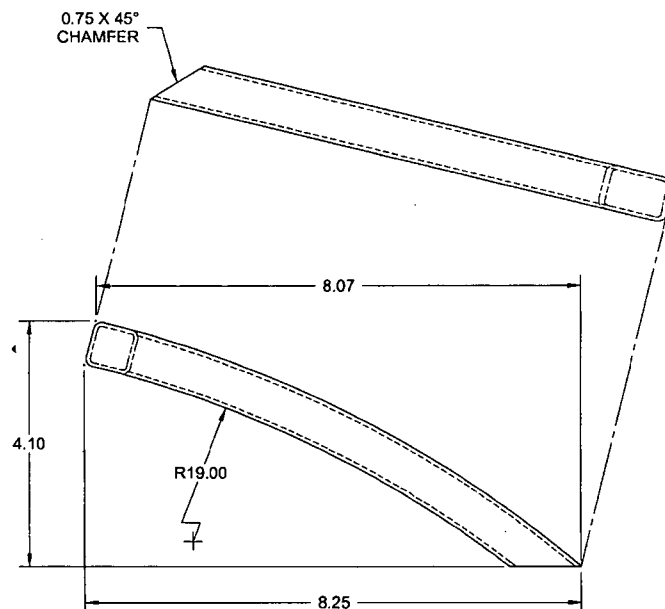
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2x *SM* 09/11/11

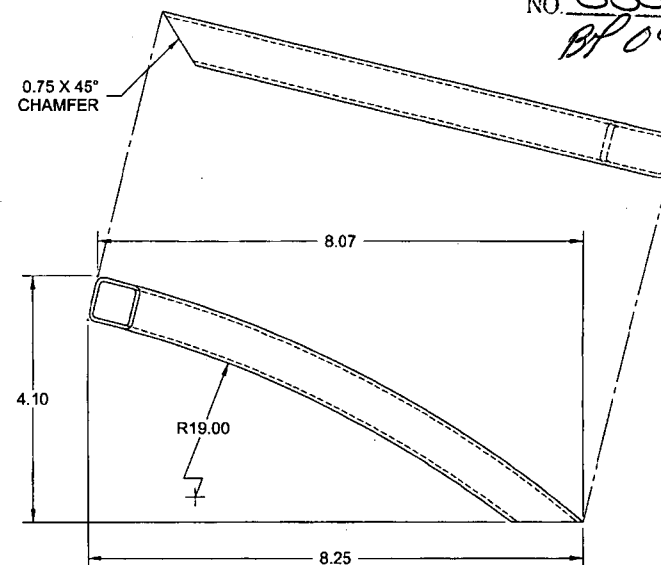
PD 09.11.11

PD 09.11.11

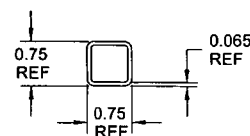
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 WORK ORDER NO. 53599
BP 09-11-9



D2989-3 RIB



D2989-4 RIB

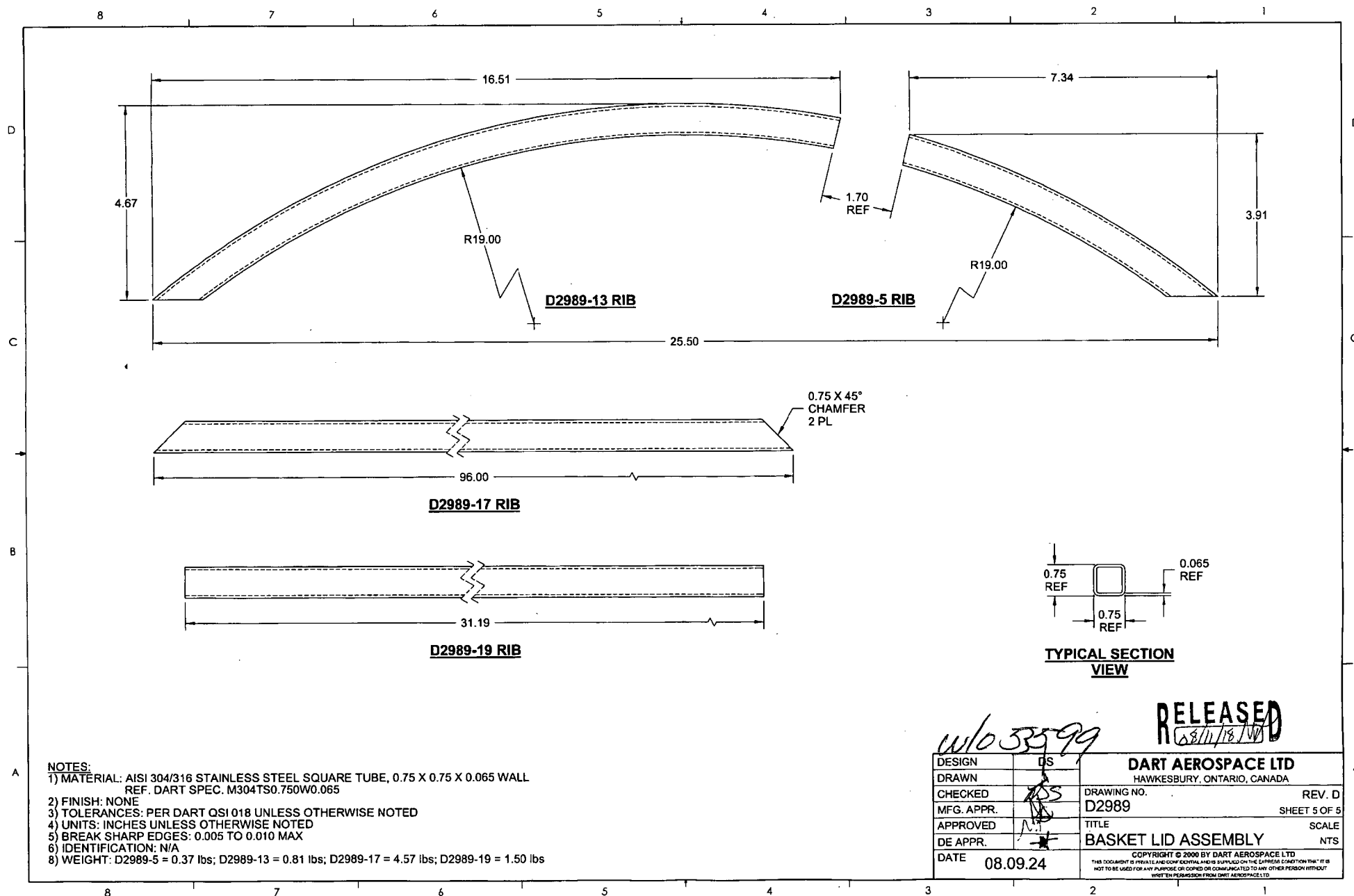


TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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DESIGN	DS	DART AEROSPACE LTD	
DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	DS	D2989	SHEET 5 OF 5
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	BASKET LID ASSEMBLY	
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RELEASED
08/11/18

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG); REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2989 TITLE BASKET LID ASSEMBLY COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. D SHEET 1 OF 5 SCALE NTS	
DATE	08.09.24		

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

